

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: **2017-13** Date Opened: **16-Jan-17**Title: **Assembly**Aircraft OEM: **Bell**Aircraft Model: **407**Product Type: **Cargo Basket**Product Model: **High Ski**Quantity: **1****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

DB
N/A
DB
DB
DB
JC
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JC
JC

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
76610	1	Basket	DB
76625	0	Placard	DB
70405	4	Lid Walkway	DB
84255	2	Handle Installation	DB
84240	0	Lid Brace Installation	DB

**Traveller**

Install walkway on lid  
Install lid on basket body  
Re-tap mounting lug holes and install mount lugs  
Install handle brackets  
Install handle  
Install lid prop  
Install data plate

Initial or N/A

DB
DB
JR
JR
JR
DB
DB

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: D. Bartfai

Sign: 

SCA: AD07

Date: 16-Jan-17

ICC / Dual Inspection preformed by:

Print: J. Clarke

Sign: 

SCA: AD02

Date: 16-Jan-17

Work Order closed by:

Print: J. Clarke

Sign: 

SCA: AD02

Date: 17-Jan-17

Approved Manufacturing Facility 73-04

Form 20.003

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

Remarks

Serviceable

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## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Handle No. of pieces: 1

Manufacturer: Aero Design Ltd

Part No.: N/A Serial No.: N/A

TTSN: N/A TSO: N/A Rem.: N/A

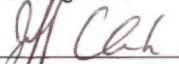
Work Order No.: 2016-160

Remaining Tasks to be Performed: Install on Basket

\_\_\_\_\_

Signature: Dan [Signature]

Date: Dec 21<sup>st</sup>/16 Lic. No. / SCA AD-07

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No. <b>2017-0032</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-013</b>
6. Item <b>1.</b>	7. Description <b>Cargo Basket Ass'y</b>	8. Part Number <b>76610-01</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>76601-26</b>	11. Status/Work <b>New</b>
12. Remarks <b>Modified with walkway on lid IAW DCL704</b>					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mm/yyyy) <b>16 Jan 2017</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<b>Installer Responsibilities</b> This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

*Beu Helicopter*



Work Order: 2017-13

Material Tracking Sheet

1 of 2

Bell 206L / 407

Date Opened: Jan 16/17

HIGH Basket Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		76610-01	<b>Cargo Basket Assembly</b>	<u>S/N 76601-26</u>	
<b>Step 1</b>				<i>Lid Assembly</i>		
	. 1		60632-01	Basket Lid Assembly		<u>2016-160</u>
Step 1.a.	. . 4		49205-14	Bumper	Argus Industries Bumper	
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		76625-01	Placard	0.050 Sheet, 6061-T6 Aluminum	<u>2015-03</u>
	. . 4		CR3213-4-02	Cherry Rivet		<u>16042</u>
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<u>16017</u>
	. . A/R		CR3213-4-02	Cherry Rivet		<u>16042</u>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	. 1		76611-01	Basket Body Assembly		<u>2016-160</u>
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	
	. . 8		NAS1149F0663P	Washer		
<b>Step 3</b>				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	90"	<u>16030</u>
	. 8		CR3523-5-02	Cherry Rivet		<u>16005</u>
	. A/R		CR3213-5-02	Cherry Rivet		<u>16042</u>
<b>Step 4</b>	. 1	84255	84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	<u>2016-37</u>
	. . 4		AN3-11A	Bolt		
	. . 8		NAS1149F0363P	Washer		
	. . 4		MS21044N3	Nut		

Work Order: \_\_\_\_\_

## Material Tracking Sheet

2 of 2

Bell 206L / 407

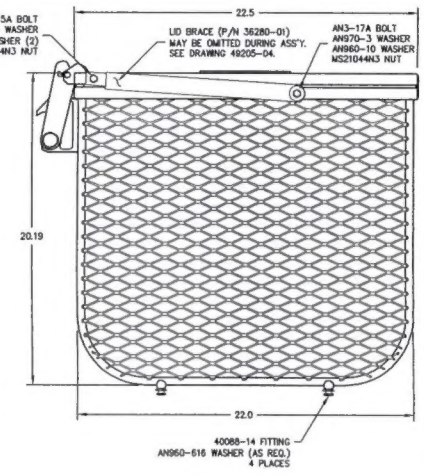
Date Opened: \_\_\_\_\_

HIGH Basket Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		2016-160
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	
	.. 2		AN3-12A	Bolt		
	.. 4		NAS1149F0363P	Washer		
	.. 2		MS21044N3	Nut		
Step 5				Lid Brace Installation		
	. 1		84280-01	Brace Assembly		2016-145
	. 1		AN3-15A	Bolt		
	. 1		AN3-17A	Bolt		
	. 2		AN970-3	Washer		
	. 3		NAS1149F0363P	Washer		
	. 2		MS21044N3	Nut		
Step 6				Inspection	None	

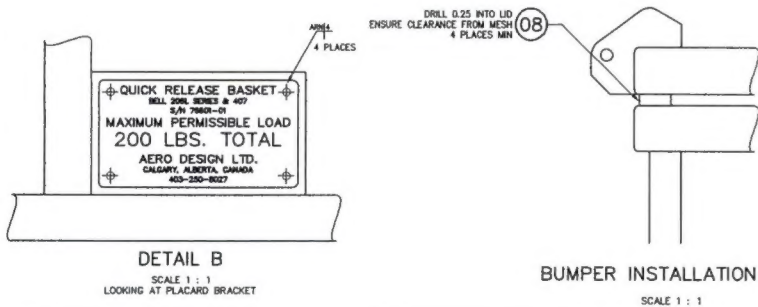


REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	CREATED FROM 60630	BJC	SEPT 25/07
1	HANDLE UPDATED TO 842 CONFIGURATION	BJC	NOV 20/12



NOTE:

1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.



2	MS21044K3	NUT	
2	AN970-3	WASHER	
3	AN960-10	WASHER	
1	AN3-17A	BOLT	
1	AN3-15A	BOLT	
4	CR3213-4-02	CHERRY RIVET	
8	CR3523-5-02	CHERRY RIVET	
A/R	CR3213-5-02	CHERRY RIVET	
A/R	AN960-616	WASHER	
4	40088-14	FITTING	ANORA
A/R	49205-14	08 BUMPER	ARGUS INDUSTRIES
1	84625-01	07 PLACARD	
1	74255-01	06 HANDLE BAR INSTALLATION	
1	MS2000HP4	05 PIANO HINGE	
1	36280-01	04 BRACE ASSEMBLY	
1	60632-01	03 LID ASSEMBLY	
1	76611-01	02 BASKET BODY ASSEMBLY	
1	76610-01	01 CARGO BASKET ASSEMBLY	
QTY.	PART NO.	ITEM	DESCRIPTION MATERIAL
LIST OF MATERIALS			




## LIST OF MATERIALS

AERO DESIGN LTD.

CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M  
2013 - 36TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7  
tel: (403) 250-8027 fax: (403) 360-8333 aarodesign@shawplanet.net

BELL 407, 206L SERIES  
QUICK RELEASE HIGH MOUNTED CARGO BASKET  
CARGO BASKET ASSEMBLY

SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	76610	1

BASIC CODE REF. NAS 323		DASH NO. FOR DIMETER F=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE		APPROVALS		DATE	
C=COUNTERSINK D=DIMPLE DITD=T OF SHEETS TO BE DIMPLED		DASH NO. FOR LENGTH		DRAWN: JEFF CLARKE CHECKED: E. BURGIN		25 SEPT 2002	
BB = MS20470AD BB = MS20426AD ARN = CR3523 ATN = CR3523		 INSTALL NEW RIVET   REMOVE/REPLACE RIVET   EXISTING RIVET		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			
				DECIMALS .XXX $\pm 0.03$ .XX $\pm 0.1$		ANGLES $\pm 1/2^\circ$	



THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

## NOTES

- DRILL #30 (0.129)  
4 PLACES



P\_02617081VCA-378225\_0.dwg, 6/12/2009 3:54:03 PM




REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD600N, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	BJC	28/05/2014



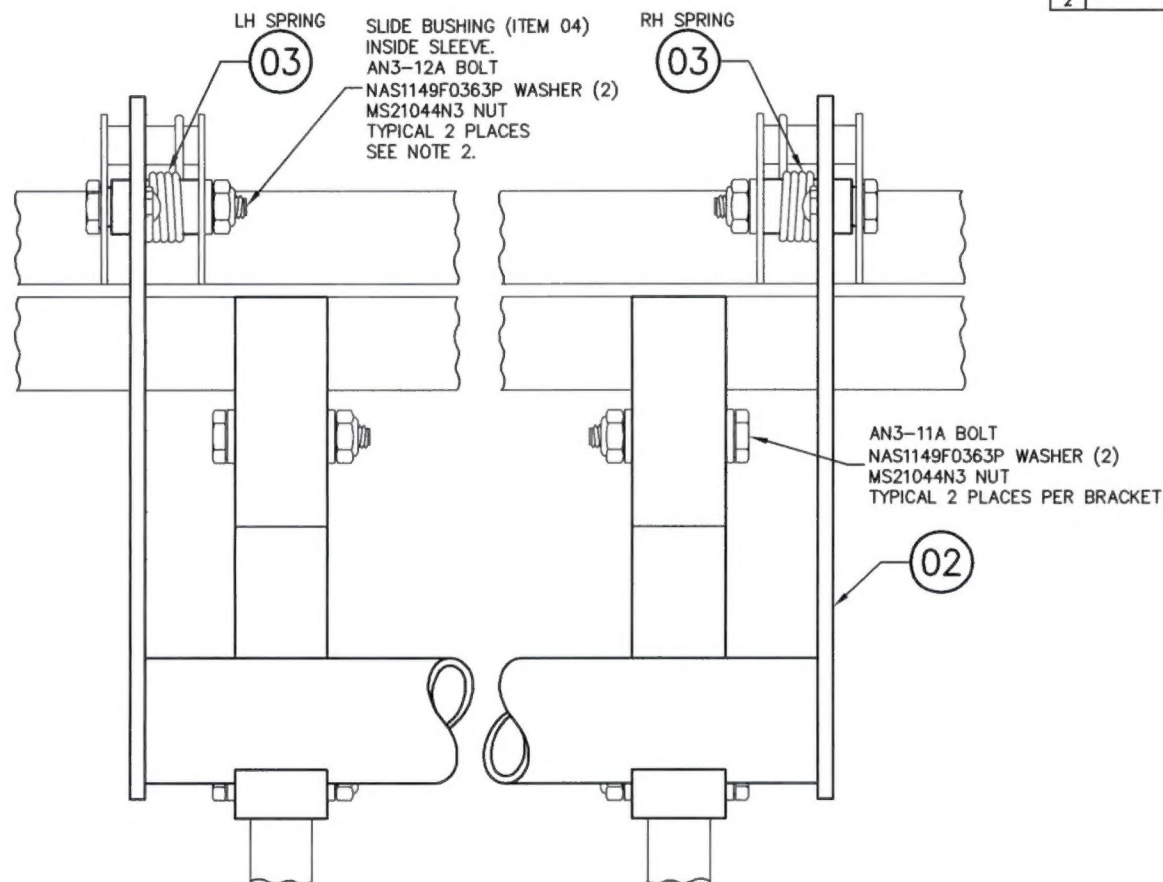
1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
2. TREAD PLATE (S) MUST BE WELDED TO LID BEFORE MESH IS WELDED ON BOTTOM.
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2865C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUD-ASSEMBLIES PRIOR TO ASSEMBLY.
7. TREAD PLATE PLATE AFTER POWDER COATING.
8. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 740402 ON ADJOINING BAY OF THE LID.

A/R	GR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02			
1	70405-04-04	TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE	
2	70403-03-03	TUBE	4130 STEEL COND. N	MIL-T-8738	0.5 X 0.035 WALL THICK	
1	SEE NOTE 1-01	BASKET LID ASSEMBLY				
1	70405-01-02	BASKET LID ASSEMBLY - MODIFIED WITH STEP				
Q1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

BASIC CODE REF: NAS 923		DASH NO. FOR DIMETER N=MTD. HEAD F=MPD. HEAD FAR SIDE		APPROVALS DRAWN: JEFF CLARKE CHECKED: E BURGIN		DATE 21 SEPT 2008				<b>AERO DESIGN LTD.</b> 8888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V6A 0G3 TEL: 604-683-5375      www.aerodesign.ca	
C=COUNTERSINK D=DRILL DIGIT=# OF SHEETS TO BE DRILLED		DASH NO. FOR LENGTH		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		CARGO BASKET LID STEP MODIFICATION		Dwg. SIZE 1/8" x 1/4"		Dwg. NO. 70405	
BASIC CODES: BB=MS20470AD BB=MS20426AD ARN=CR3213 ARN=CR3212		+ INSTALL NEW RIVET - REMOVE/REPLACE RIVET - ENDING RIVET		DECIMALS X.XX ±0.010 X.XX ±0.03 X.X ±0.1		ANGLES ±1/2°		SCALE 1 : 1.5		SHEET 1 OF 1	
								A1		4	

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.

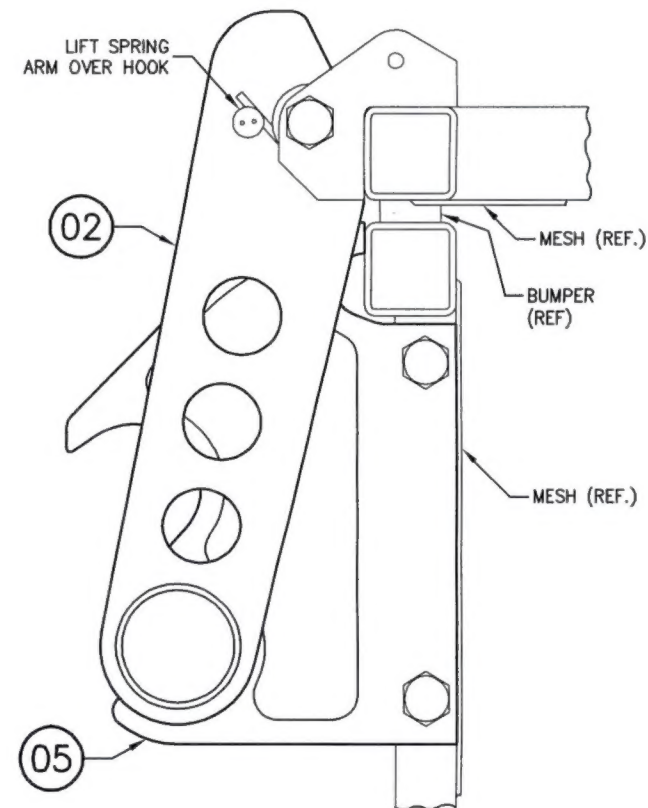


01 HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14



APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGOIN	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	
DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	



**AERO DESIGN LTD.**

9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 804.483.2376 www.aerodesign.ca

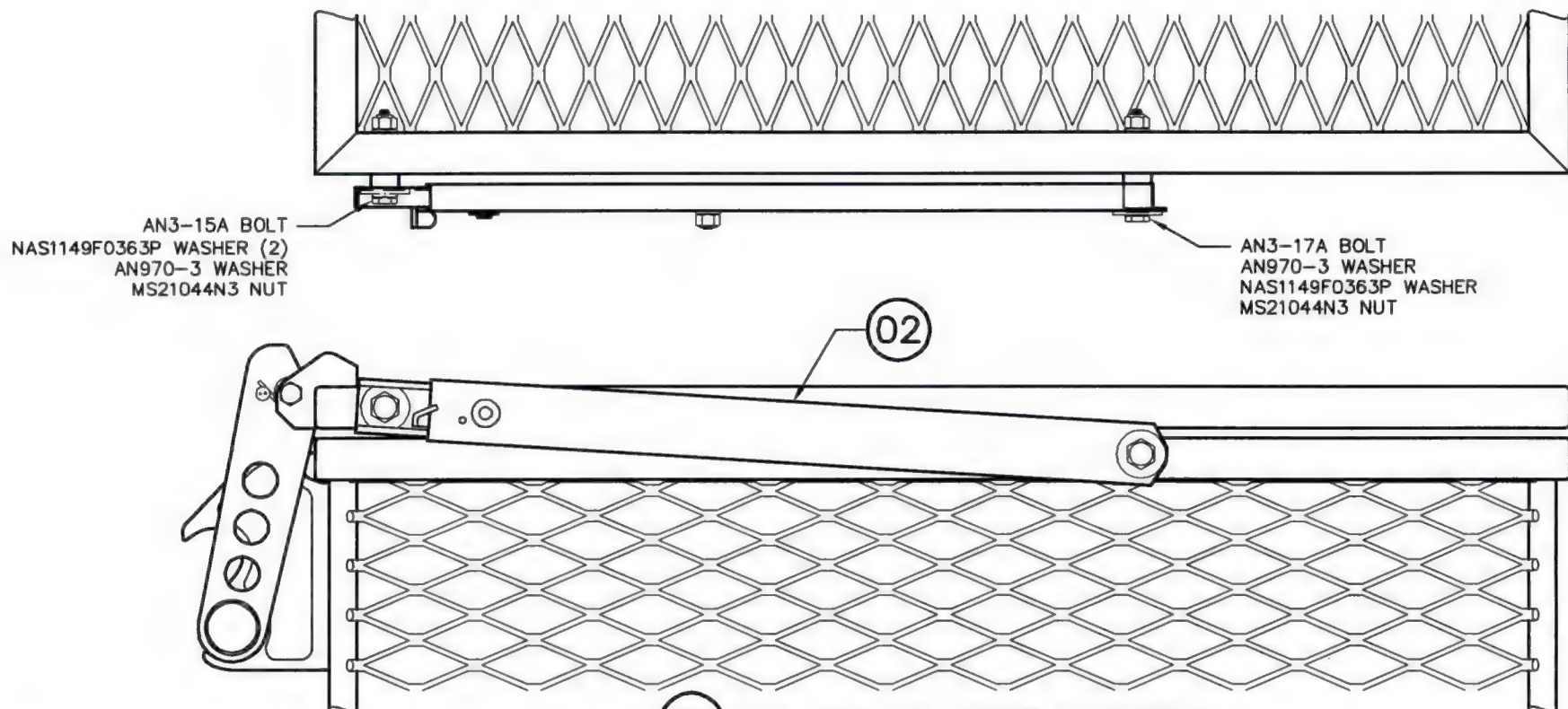
**HELICOPTER CARGO BASKET  
HANDLE BAR INSTALLATION**

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2




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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



#### NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.  
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

2	MS21044N3		NUT	APPROVALS	DATE		<b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.493.2379      www.aerodesign.ca			
3	NAS1149F0363P		WASHER	DRAWN: JEFF CLARKE	21 MAY 2014					
2	AN970-3		WASHER	CHECKED: JASON REKVE	21 MAY 2014					
1	AN3-17A		BOLT							
1	AN3-15A		BOLT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS      ANGLES X.XXX ±0.010      ±1/2" X.XX ±0.03 X.X ±0.1		<b>HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION</b>				
1	36280-01	02	LID BRACE ASSEMBLY							
	84240-01	01	LID BRACE INSTALLATION							
01	PART NO.	ITEM	DESCRIPTION			NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.	
QTY.	LIST OF MATERIALS					SHEET 1 OF 1	A4	84240	0	





WO# \_\_\_\_\_

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

1

MS20001P4-9600

All

Model: All

on:

Hinge

Bisco Industries

N/A

WO#:

N/A

PO# 16030

## **CARGO BASKET ASSEMBLY - COMMON**

### **General**

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407 – Right side only**

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

#### **Eurocopter AS350/AS355 – left or right**

77610, Revision 1 – Short Basket

76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

94010, Revision 0 – Extra Large (ski) Basket

#### **Robinson R44 – left or right**

90610, Revision 0 – Standard Basket (left or right)

#### **Bell 206B – right side only**

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

#### **Bell 429 – right or left**

95911, Revision 0 – Standard Basket

#### **Bell Medium – left or right**

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

#### **MD600**

82811, Revision 0 – Standard Basket

#### **Options**

70405, Revision 3? – Lid Walkway



## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

Work Order: 2017-13

Date Open: 16 Jan 2017

AD  
73-04  
07

### 1. Lid Assembly

- a. Install lid bumpers on bottom.
  - i. Fill bumper holes with RTV silicone sealant.
  - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
  - i. Locate placard on bracket.
  - ii. Drill #30 through placard and bracket, using holes in placard.
  - iii. Remove placard and de-burr holes in placard and on bracket.
  - iv. Locate placard on bracket, and cleco in place.
  - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
  - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
  - ii. Pull tread plate from stock. Shear tread plate to length.
  - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
  - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
  - v. Mark and drill #30 holes:
    1. 0.25" from edge of tread plate, centre on cross members (0.38")
    2. 0.25" from edge of tread plate, middle of each walkway stringer
  - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
  - vii. De-burr holes in lid tubes.
  - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
  - ix. Set tread plate in place, secure with clecos if necessary.
  - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

### 2. Body Assembly

- a. Install attachment fittings
  - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
  - ii. Run 3/8-24 tap into attachment lugs to clear threads.
  - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ankra 40088-14)
  - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
    1. 90610 (Robinson R44) basket only:
      - a. Install 1 fitting 906?? in lower forward attachment lug only.
      - b. Install 3 96710-01 fittings in remaining locations.
  - v. Torque to ??

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
  - i. Locate 94621-01 Brace over aft cross tube cutout
  - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
  - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

### 3. Hinge Installation

- a. Prepare hinge.
  - i. Cut hinge to length:
    - 1. 776, 906 – 54"
    - 2. 751, 803 – 70"
    - 3. 698, 764, 945 – 72"
    - 4. 784 – 90"
    - 5. 940, 946, 959 – 95"
  - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
  - i. Locate hinge on basket (standard baskets)
    - 1. centre fore/aft
    - 2. 0.15" – 0.18" up from bottom edge
  - ii. Locate hinge on basket (extra wide baskets)
    - 1. centre fore/aft
    - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - v. Remove hinge and de-burr holes in hinge and basket rim.
  - vi. Cleco hinge to basket with 5/32 clecos.
  - vii. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations





- d. Record PO of hinge and rivets on attached material tracking list.

#### 4. Install Handle

a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

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#### 5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.



## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

### 6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
  - i. Bolts are tight
  - ii. Rivets are installed correctly
  - iii. Handle operates correctly
  - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

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